

64

SG Blanks

Dart Aerospace Ltd.

Date: Friday, 2/23/2007 8:31:12 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	RADIUS BLOCK
Job Number	30875		
Estimate Number	10822		
P.O. Number	N/A	Part Number	D2274
This Issue	2/23/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D2274 REV F
First Issue	N/A	Project Number	N/A
Previous Run	30518	Drawing Revision	F
Written By		Material	N/A
Checked & Approved By		Due Date	3/30/2007
Comment	Est. H 00.05.18 Added inspection level 8 EC	Qty:	500
Um:	Each		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0750X00125	6061-T6 Bar .75" x .125"
	Comment: Qty.: 0.0962 f(s)/Unit Total : 48.0900 f(s) 6061-T6 Bar .75" x .125"	
	Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" BarBatch M103713	
2.0	SHEAR	SHEAR
	Comment: SHEAR Shear blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces	SD 01.03.07 569
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio D2274	MR / SD 01.03.07 569
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	MR / SD 01.03.08 569
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	J.L 07/03/08 569
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble Deburr any rough edges after tumbling	MR 07/03/09 569

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/03/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RADIUS BLOCK

Job Number: 30875

Part Number: D2274

Job Number:

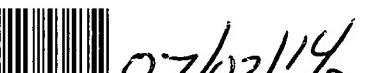


Seq. #: Machine Or Operation:

Description :

7.0 HAND FINISHING1

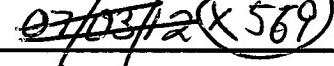
HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

EF M.R.



8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/03/15 (569)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/03/15 (569)

1

(569)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/19

Job Completion



U 07.03.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30875
Description: Radius Block	Part Number:	D2274
Inspection Dwg: D2274 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>SD</u>	Audited by:	<u>Cy</u>	Prototype Approval:	<u>N/A</u>
Date:	07.03.01	Date:	07.03.01	Date:	

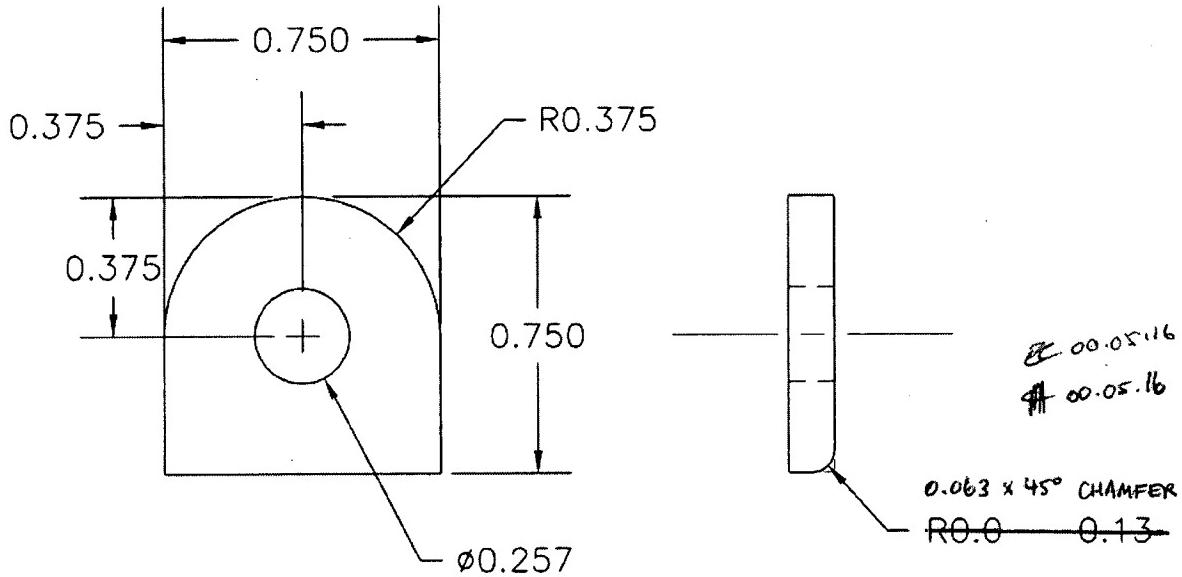
Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	



DRAFT ISSUE

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MJ</i>	APPROVED <i>GS</i>	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/18 KE



MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30875

